

SPLIT

Work Order ID 67661-1

Tuesday, March 29, 2011 9:22:18 AM



Page 1

Item ID: D2574

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 3/30/2011 Start Qty: 12.00

Required Date: 4/13/2011 Req'd Qty: 12.00

Reference:

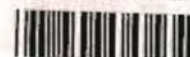
Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-03-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program Batch No. 67661 Double check by: B.A. 11/04/05
1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and insp

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Machine keyway as per dwg D2573 & D2574

B.A. 11/04/05

Re 11.5.10

120



QC

Quality Control

QC2- Inspect parts off machine FA1/FA1B

0.00

Memo

0.00

B.A. 11/04/06

Re 11.5.10

Work Order ID 67661

Tuesday, March 29, 2011 9:22:19 AM



Page 2

Item ID: D2574

Accept

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 3/30/2011 Start Qty: 12.00

Required Date: 4/13/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130
QC
Quality Control

QC8- Inspect parts - second check

0.00

21/05/11

Memo

0.00

6

140
Hand Finish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

6x Ø m/f 11/05/11

150
Powdercoat
Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME

320 3:10 FINISH TIME:

0.00

OVEN TEMPERATURE:

3:40

6x Ø m/f 11/05/12

Work Order ID 67661

Tuesday, March 29, 2011 9:22:19 AM



Page 3

Item ID: D2574

Accept

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 3/30/2011 Start Qty: 12.00

Required Date: 4/13/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

x6 d 34 wlos162

170



Packaging

Packaging

Identify as per dwg & Stock Location 434

0.00

Memo

0.00

Per 11/10/12 (6)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/15/16

ME

11-05-13

Picklist Print

Tuesday, March 29, 2011 9:22:16 AM

Page 1

Work Order ID: 67661

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 3/30/2011

Required Date: 4/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	87.0000	1	12			
Saddle Billet													

Location	Loc Qty	Loc Code
MAT045	30	
66966	30	
MAT046	57	
65382	17	
65953	20	
66966	20	

5
4
3

B.A 11/04/05

219

DART AEROSPACE LTD	Work Order:	0766/
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443						Vein	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.002	8.002	8.002	8.002	Vein	CNC-02
F	0.490	0.510		.499	.495	.498	.497	Vein	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.501	.501	.503	.503	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.568	.569	.568	.568	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.128	.128	.125	.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vein	GA-01
R	0.240	0.260		.255	.255	.255	.255	"	"
S	0.115	0.135		.122	.119	.122	.122	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vein	GA-01
V	0.230	0.250		.241	.241	.241	.241	"	"
W	0.115	0.135		.125	.125	.125	.125	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vein	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.367	.367	.367	.367	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		.627	.627	.627	.627	Vein	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		.255	.255	.255	.255	Vein	GA-01
AE	1.500	1.520		1.516	1.515	1.511	1.511	H-6	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vein	GA-01
AG	0.240	0.280		.256	.256	.256	.256	"	"
AH	0.240	0.260		.254	.254	.254	.254	"	"
AI	2.000	2.020		2.003	2.0025	2.002	2.002	H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vein	GA-01
Accept/Reject									

Measured by: J.A. 20	Audited by: J.
Date: 11/04/05	Date: 11/05/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 6766/
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

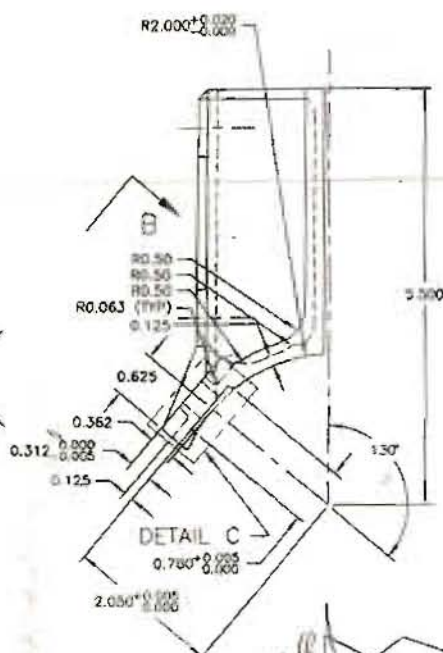
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C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
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E	7.990	8.010		8.002	8.002	8.002	8.002	Vern	CNC-02
F	0.490	0.510		.495	.495			Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		.501	.501			"	"
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Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
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AG	0.240	0.280		.257	.256			"	"
AH	0.240	0.260		.254	.254			"	"
AI	2.000	2.020		2.002	2.002			H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

Measured by: RCP
Date: 11.5.10

Audited by: ST
Date: 11/5/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



05.12.06 ~~11~~